

**Work Order ID 74011**

Tuesday, September 20, 2011 11:18:02 AM



Page 1

Item ID: D3472-5

Accept



Setup Start



Revision ID:

Item Name: Flat Doubler

Stop



Start Date: 9/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *P*Date: *109-20* Tooling: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3472    | Rev A        |

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

*2004 .003*

Memo

Cut as per Dwg D3471  Dwg Rev: *A*  Prog Rev: *A**B11-9-07**(8)*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

0.00

*B11-9-07*

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

0.00

*Sulorl28**(X8)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                  |                                 |                |                           |                       |                          |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action      Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng             | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 74011**

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Page 2

Item ID: D3472-5

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Setup Start



Revision ID:

Item Name: Flat Doubler

Stop



Start Date: 9/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- Deburr  2- Buff out scratches

0.00

140



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

8/20/11 09:28

150



QC - Inspect part completeness to step on W/O

0.00

QC

QC

Memo

0.00

Quality Control

8/20/11 09:28

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                  |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng             | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 74011**

Tuesday, September 20, 2011 11:18:02 AM



Page 3

Item ID: D3472-5

Accept



Setup Start



Revision ID:

Item Name: Flat Doubler

Stop



Start Date: 9/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



Packaging

Operation  
Description

Identify as per dwg &amp; Stock Location: S1058

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

8X SP 11-09-28

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

n/a 11/10/13 JJ

n/a 11-09-28

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 11:18:08 AM

Page 1

Work Order ID: 74011



Parent Item: D3472-5



Parent Item Name: Flat Doubler

Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev. A 06.02.02 new issue EC  
IPP rev. B 06.03.29 added alodine EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.063                    |                        | Purchased     |             | No                  |                  | 100             | sf                 | 116.5000       | 1.0884      | 4.582737     | 1.            |                |        |

2024-T3 .063 sheet



| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT022   | 116.5   |          |
| 117392   | 116.5   |          |

Location

Loc Qty

Loc Code

117392

(8)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                  |                                 |                |                           |                       |                          |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action      Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng             | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 74011

Description: FIAT Double

Part Number: D3472-5

Inspection Dwg: D3472-4 Rev: A

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      X Prototype

Measured by: KB  
Date: 11-9-27

Audited by: S  
Date: 11/08/28

|                     |  |
|---------------------|--|
| Prototype Approval: |  |
| Date:               |  |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |

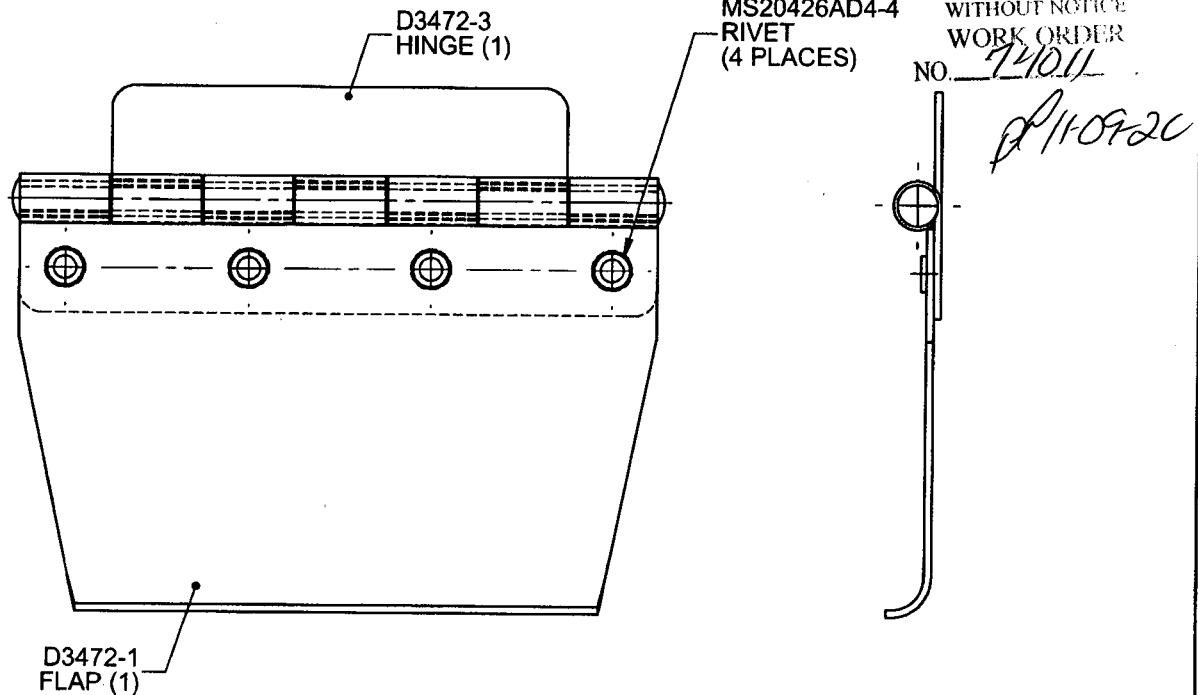
**DART**

|                         |                       |  |
|-------------------------|-----------------------|--|
| DESIGN<br><i>JB</i>     | DRAWN BY<br><i>JB</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>A</i>     | APPROVED<br><i>A</i>  | DRAWING NO.<br><b>D3472</b>                              |
| DATE<br><b>06.01.17</b> |                       | REV. A<br>SHEET 1 OF 4                                   |
|                         |                       | TITLE<br><b>HEAT OUTLET DEFLECTOR</b>                    |

A 06.01.17 NEW ISSUE

06.04.03 *SH*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDERNO. *P110920*

### **D3472-041 CABIN HEAT OUTLET DEFLECTOR**

**NOTES:**

- 1) IDENTIFY WITH DART P/N D3472-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-041 | P/N          | DESCRIPTION                        |
|-------------|--------------|------------------------------------|
| X           | D3472-041    | <b>CABIN HEAT OUTLET DEFLECTOR</b> |
| 1           | D3472-1      | FLAP                               |
| 1           | D3472-3      | HINGE                              |
| 4           | MS20426AD4-4 | RIVET                              |

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

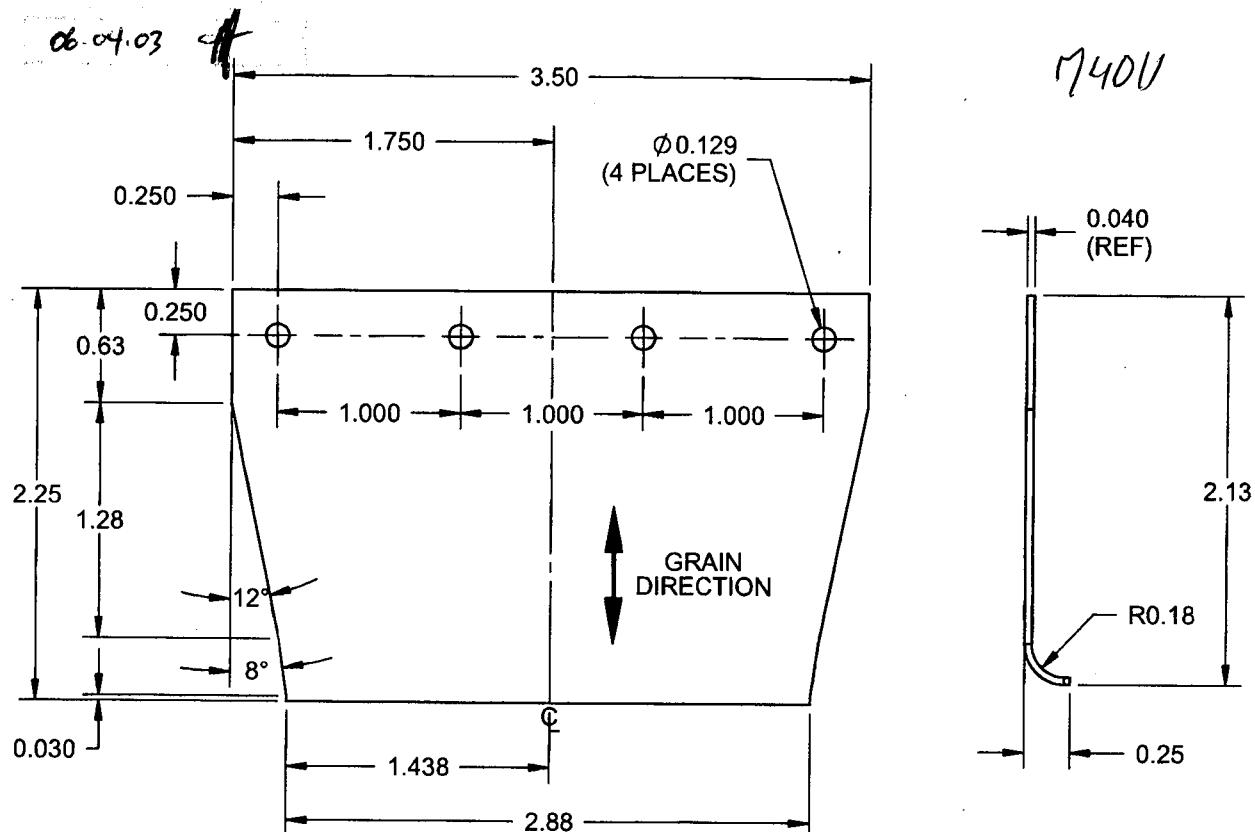
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                     |                                |   |                        |
|---------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>B</i>  | DRAWN BY<br><i>B</i>           | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>H</i> | APPROVED<br><i>H</i>           | DRAWING NO.<br>D3472                              | REV. A<br>SHEET 2 OF 4 |
| DATE<br>06.01.17    | TITLE<br>HEAT OUTLET DEFLECTOR | SCALE<br>1:1                                      |                        |

**D3472-1F FLAP FLAT PATTERN****D3472-1 FLAP  
BENDING DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

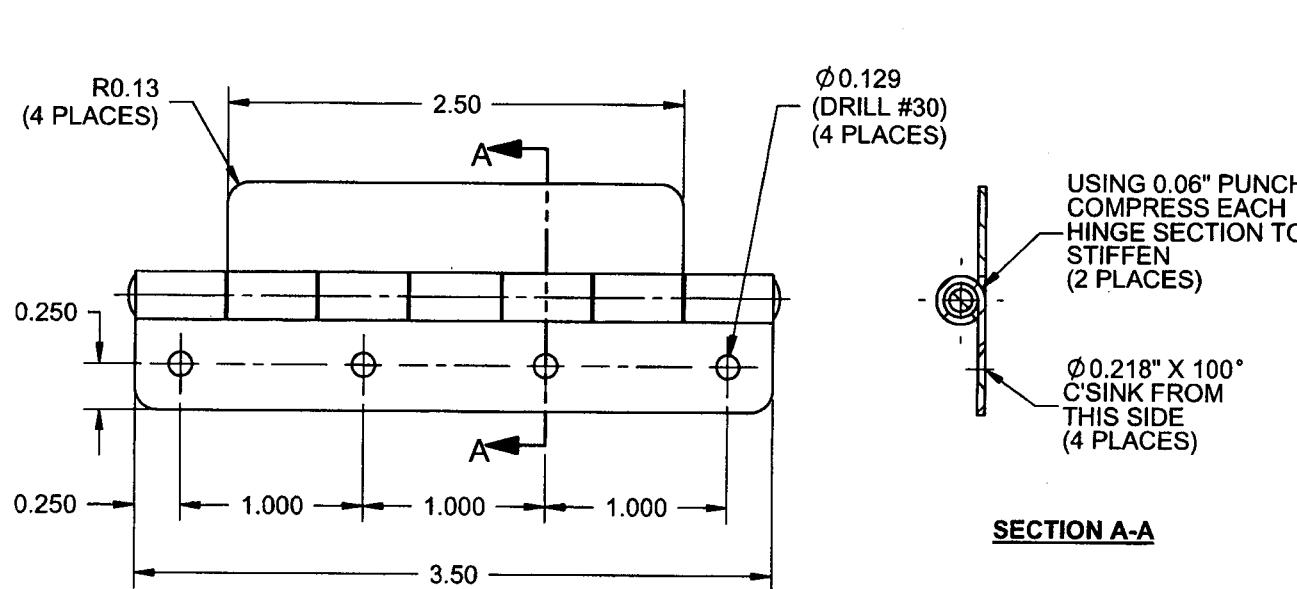
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                     |                                |   |                        |
|---------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>BS</i> | DRAWN BY<br><i>BS</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>#</i> | APPROVED<br><i>#</i>           | DRAWING NO.<br>D3472                              | REV. A<br>SHEET 3 OF 4 |
| DATE<br>06.01.17    | TITLE<br>HEAT OUTLET DEFLECTOR | SCALE<br>1:1                                      |                        |



### D3472-3 HINGE

#### NOTES:

- 1) MAKE FROM MS20257-3 HINGE, MODIFIED AS SHOWN
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

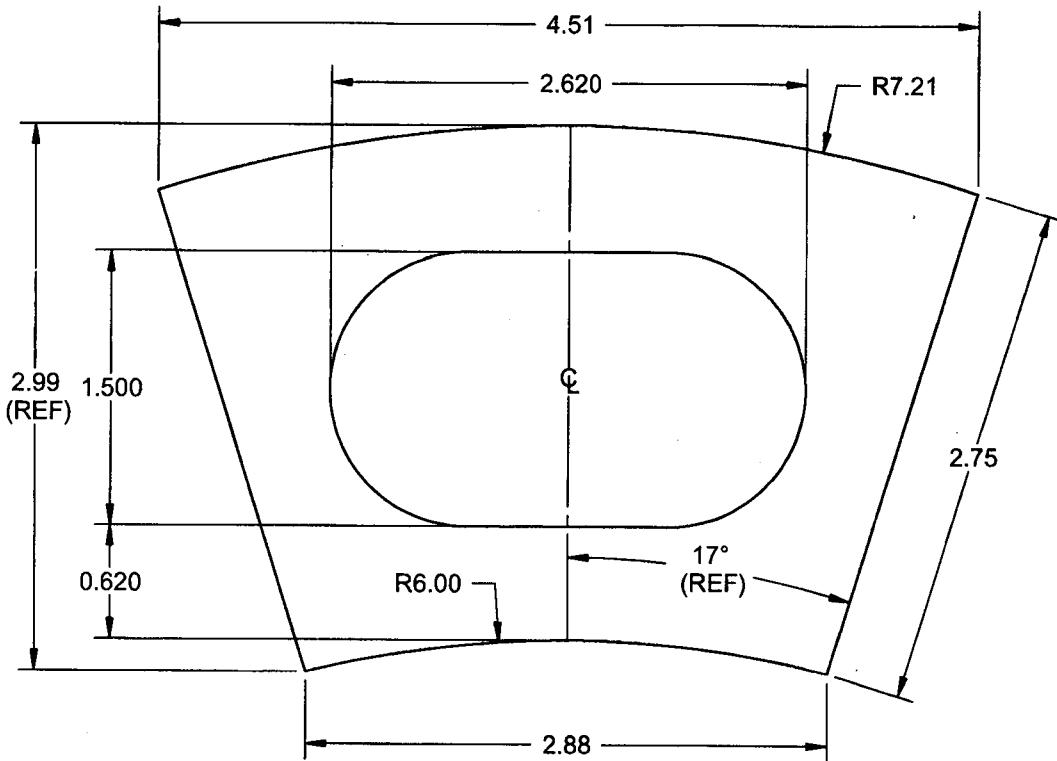
NOTE: Date & initial all entries

**DART**

|                     |                                |   |                        |
|---------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>B</i>  | DRAWN BY<br><i>B</i>           | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>H</i> | APPROVED<br><i>H</i>           | DRAWING NO.<br>D3472                              | REV. A<br>SHEET 4 OF 4 |
| DATE<br>06.01.17    | TITLE<br>HEAT OUTLET DEFLECTOR | SCALE<br>1:1                                      |                        |

06.04.03 *H*

7401

**D3472-5 FLAT DOUBLER****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) IDENTIFY WITH DART P/N D3472-5 USING  
FINE POINT PERMANENT INK MARKER
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries